



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4297-3

Job Sheet 179587



Part No: D4297-3

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 12-07-25 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/16/18	0.00	0.00	Start Up Waterjet		De 18/06/30
120	Waterjet	6 pcs		7/16/18	0.00	1.69	Waterjet1		DAS 18/06/30
130	CNC Vertical Machining	6 pcs		7/16/18	0.00	11.95	HAAS1-4		52 18/08/20
140	QC	6 pcs		7/16/18	0.00	0.00	QC2 Machining-2		9-89 18/08/20
150	QC	6 pcs		7/16/18	0.00	0.00	QC8 Machining-2		mm L 18/08/25
151	Packaging	6 pcs		7/16/18	0.00	0.00	Packaging3	51442	AUG 27 2018 6
190	QC21-SA	6 Ea		7/16/18	0.00	0.00	QC21		21 AUG 28 2018 9-89

Part Op 120 - Cut Blank as per D2432 File (SAME BLANK AS D2432)

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA127 and Dwg DWG

REV: C FOLIO REV: C 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	22.2000 sf (3.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	22	1,376	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 10:31 AM Dart.lajeunesse.marie

Date: 06/30/18

DART AEROSPACE LTD		Work Order:	17587
Description: Bearpaw		Part Number:	D4297-3
Inspection Dwg: D4297 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	
B	0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver	
C	R0.250	+/-0.030	R0.25	✓		R/G	
D	0.63	+/-0.030	0.64	✓		Ver	
E	0.38	+0.030/-0.010	0.40	✓		Ver	
F	0.95	+0.030/-0.030	0.96	✓		Ver	
G	19.000	+/-0.030	19.000	✓		TAPE	
H	Ø0.260	+0.005/-0.001	Ø.260	✓		G.P.	
I	Ø0.93	+/-0.030	.931	✓		Ver	
J	0.30	+0.030/-0.000	.310	✓		Ver	
K	23.750	+/-0.030	23.750	✓		TAPE	
L	2.00	+/-0.030	2.00	✓		Ver	
M	0.47	+/-0.030	.465	✓		Ver	
N							
O							
P							
Q							
R							
S							
T							
U							

Measured by:	DAS 52 3-89	Audited by:	mm L	Preliminary Approval:	
Date:	18/08/20	Date:	18/08/25	Date:	

Rev	Date	Change	Revised by	Approved
A	15.02.03	New Issue	KJ	
B	15.02.09	Dimensions revised	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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